

Date: Tuesday, 12/5/2006 8:15:45 AM  
User: Kim Johnston

## **Process Sheet**

|   |   |  |               |
|---|---|--|---------------|
| Customer                                | : CU-DAR001 Dart Helicopters Services             | Drawing Name                           | : LUG         |
| Job Number                              | : 29780A  |  |               |
| Estimate Number                         | : 10338   |  |               |
| P.O. Number                             | : N/A   | Part Number                            | : D2657       |
| This Issue                              | : 12/5/2006                                       | Drawing Number                         | : D2657 REV A |
| Prsht Rev.                              | : NC  | Project Number                         | : N/A         |
| First Issue                             | : N/A   | Drawing Revision                       | : A           |
| Previous Run                            | : 29228A  | Material                               | : N/A         |
| Written By                              | :   | Due Date                               | : 1/5/2007    |
| Checked & Approved By                   | : 06/12/05  | Qty:                                   | (40)          |
| Comment                                 | : Est Rev: A New Issue 05-11-07 JLM               | Um:                                    | Each          |
| <b>Additional Product</b>               |   |  |               |
| Job Number:                             |   |  |               |
| Seq. #:                                 | Machine Or Operation:                             | Description :                          |               |
| 1.0                                     | M1010B0750X02500                                  | ASTM A21 Steel .75"x2.5"               |               |
|   |   |  |               |
| Comment:                                | Qty.: 0.1925 ft(s)/Unit Total: 7.6986 ft(s) 7.892 |  |               |
| Material:                               | ASTM A36 steel bar 2.50" x 0.75" thick            |  |               |
| (M1010-B0.750 x 02.500)                 |   |  |               |
| Batch                                   | 103069  | 36                                     | 07.01.17      |
| 2.0                                     | BAND SAW  | BAND SAW                               |               |
|   |   |  |               |
| Comment:                                | BAND SAW  |  |               |
| Cut blanks:                             | 2.200" long                                       | 36                                     | 07.01.17      |
| 3.0                                     | HAAS1   | HAAS CNC VERTICAL MACHINING #1         |               |
|   |   |  |               |
| Comment:                                | HAAS CNC VERTICAL MACHINING #1                    |  |               |
| 1-Machine per folio FA040 and Dwg D2657 |   |  |               |
| 2-Deburr                                |   | 36/15.F.                               | 07/02/16      |
| 4.0                                     | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE |               |
|   |   |  |               |
| Comment:                                | INSPECT PARTS AS THEY COME OFF MACHINE            | 36/15.F.                               | 07/02/16      |
| 5.0                                     | QC8   | SECOND CHECK                           |               |
|   |   |  |               |
| Comment:                                | SECOND CHECK                                      | 36                                     | 07/02/19      |

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/02/21  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 29780A

Part Number: D2657

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                           |                       |                          |

NOTE: Date & initial all entries

|                       |              |             |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD    | Work Order:  | 29780 A     |
| Description: Lug      | Part Number: | D2657       |
| Inspection Dwg: D2657 | Rev: A       | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J.F.     | Audited by: | S.A.     | Prototype Approval: | N/A |
| Date:        | 07/02/16 | Date:       | 07/02/16 | Date:               |     |

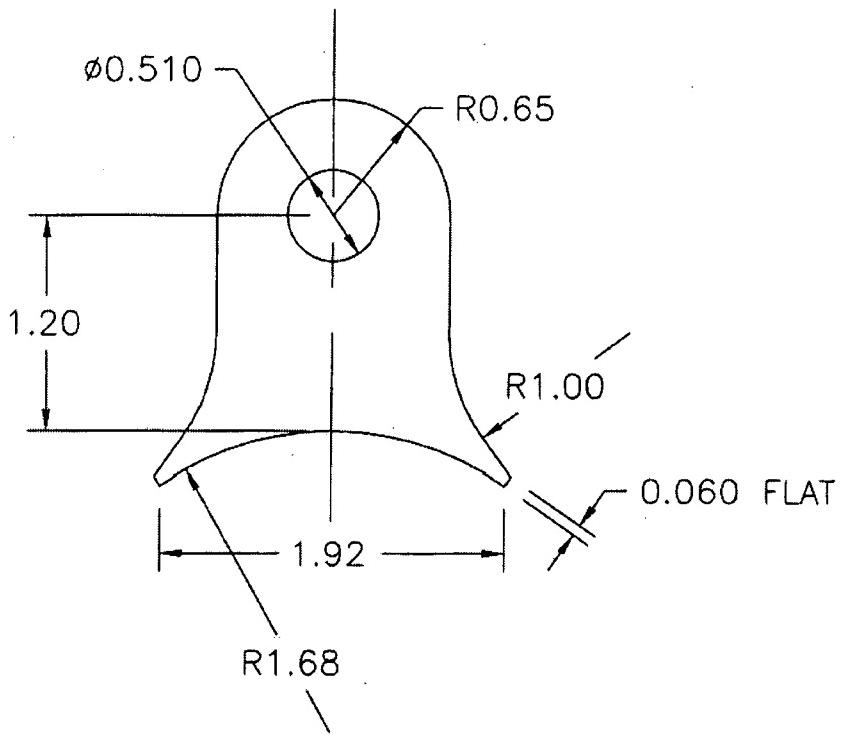
| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 03.12.23 | New Issue | KJ/RF      | JF       |



10 COPY  
GIVEN

|                      |                        |  |
|----------------------|------------------------|--|
| DESIGN<br><i>DAS</i> | DRAWN BY<br><i>DAS</i> | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |
| CHECKED<br><i>A</i>  | APPROVED<br><i>A</i>   | DRAWING NO.<br>D2657   |
| DATE<br>97.11.03     |                        | TITLE<br>LUG   |
|                      |                        | SCALE<br>1:1   |
| A                    | 97.11.03               | NEW ISSUE  |

RELEASED  
97/11/07 DS



BREAK ALL SHARP CORNERS ~~0.010~~ TO ~~0.020~~  
MATERIAL: ASTM A36 STEEL 0.375 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTER-LINE

SHOP COPY  
RETURN TO  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *29780A*